

Date: Monday, 14/05/2007 3:07:38 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT CROSSTUBE
Job Number	: 32347		
Estimate Number	: 10377		
P.O. Number	: N/A	Part Number	: D2890
This Issue	: 14/05/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2890 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32346	Drawing Revision	: B
	Type	Material	: N/A
	: PURCHASED PARTS	Due Date	: 30/05/2007
Written By	: _____	Qty:	1 Um: Each
Checked & Approved By	: _____		
Comment	: Est. D 05.03.21 Removed Bending procedures KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6008180	Crosstube extrusion
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part #	Description	Batch
1	D6008-180	Crosstube extrusion	25672

EL 7-5-15

2.0	BENDING	BENDING MACHINE
-----	---------	-----------------

**Comment:** BENDING MACHINE

1-Bend D2890 as per Dwg D2890 and Folio FT002

EL 7-5-15

3.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

Handwritten signature/initials

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Deburr and Polish

N/A

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/05/2007 3:07:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 32347

Part Number: D2890

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W/D 32356*

2006-20 (1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2006/20 (1)

Job Completion



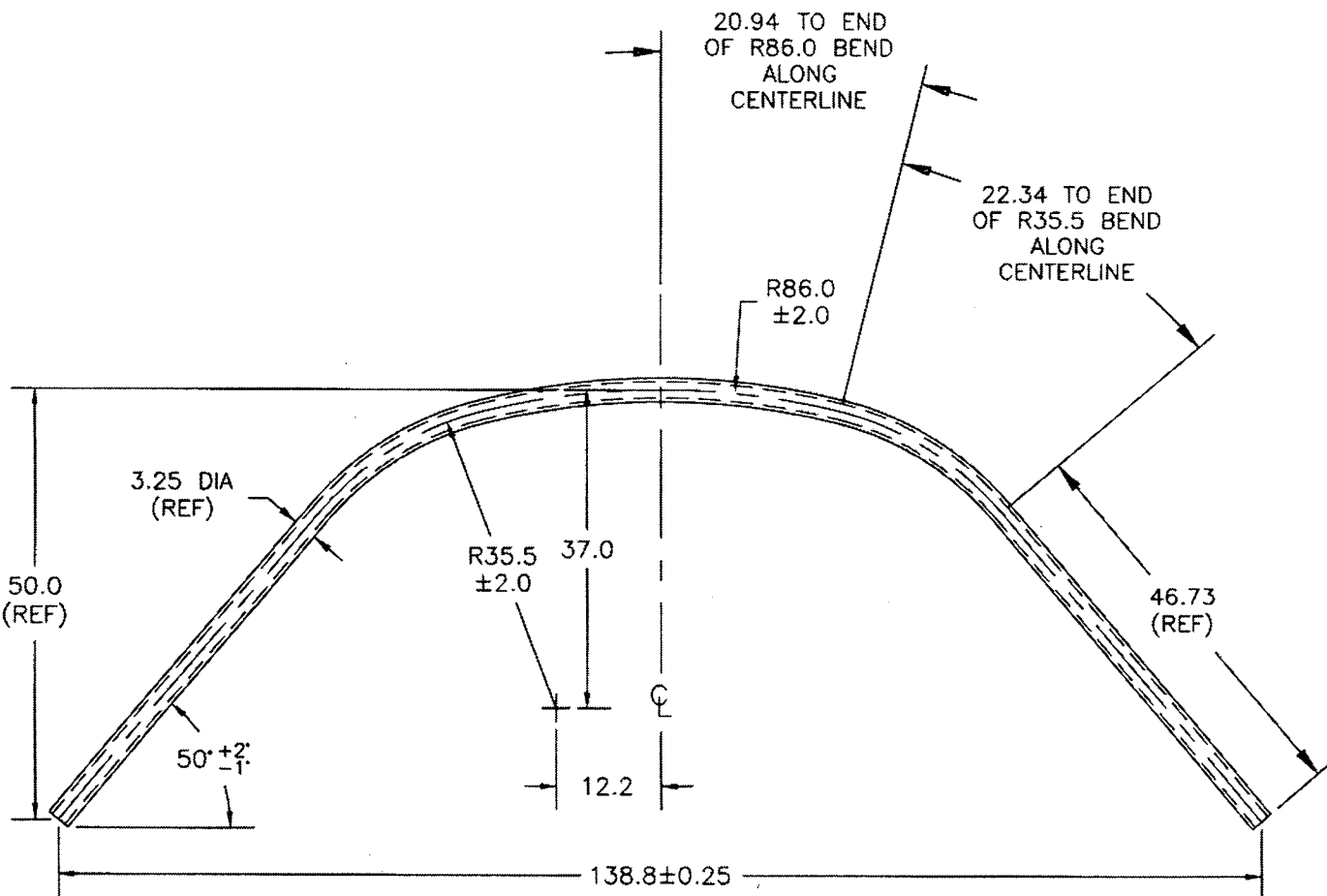
2007-10-22



RELEASED
02-10-28

DESIGN	DRAWN BY	DART AEROSPACE LTD
✓	✓	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D2890
DATE	TITLE	REV. B
02.10.18	AFT CROSSTUBE	SHEET 1 OF 1
A	99.05.21	SCALE
B	02.10.18	1:20
ADD TANGENT LENGTHS; CHANGE NOTES		

W/D 32347

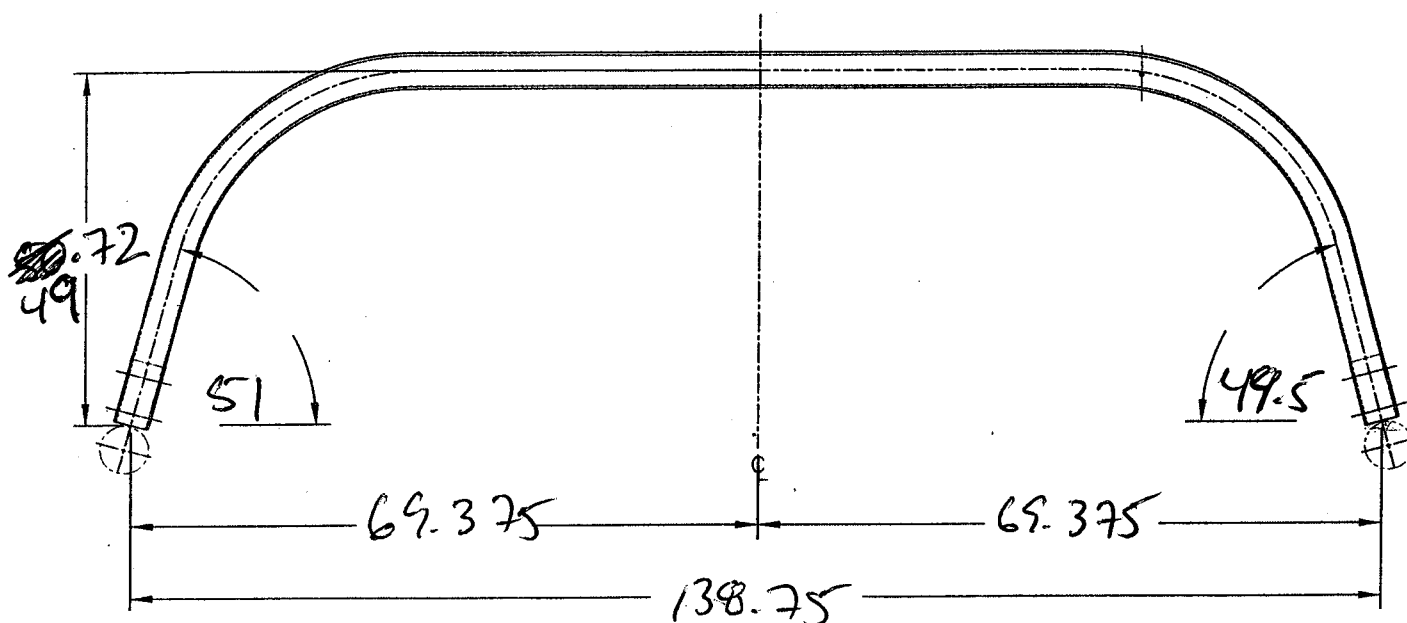


NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 (Ø3.25 OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

DART AEROSPACE LTD		Work Order:	
Description: Crosstube Aft		Part Number:	D2890
Inspection Dwg: D2890		Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
Tube used for - 103 B 32356

QC15 Inspection	<i>[Signature]</i>
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>